

Work Order ID 40893

June 26, 2009 10:36:03 AM



Page 1

Item ID: D2249-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Fitting Assembly

Start Date: 15/07/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2249

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

- SP 09.07.01

Large Fab

Weld as per Dwg D2249 and QSI 004

110

0.00

PD 09.07.02



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

120

0.00

- 80267102 (f10)



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Date: Friday, 01/08/2008 10:42:26 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 40893		
Estimate Number	: 10844		
P.O. Number	:	Part Number	: D2249041
This Issue	: 01/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2249 REV. E
First Issue	: / /	Project Number	: N/A
Previous Run	: 40486	Drawing Revision	: E
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/08/2008
Checked & Approved By	: <u>JUD 08.8.05</u>	Qty:	10 Um: Each
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E 08-07-28 chg qty of D2249-1 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	40893A	LUG
-----	--------	-----



Comment: Sub-Component LUG

2 x D2249-1 Batch B 40893 A = 20xSP 09.06.23.

2.0	40893B	LUG
-----	--------	-----



Comment: Sub-Component LUG

1 x D2249-3 Batch B 34671 B = 10xSP 09.06.23

3.0	40893C	GUSSET
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Comment: Sub-Component GUSSET

2 x D2249-5 Batch B 40893 = 17 = (20x)SP 09.06.23

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2249 and QSI 004

SP 09.07.02.

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:26 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 40893

Part Number: D2249041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

✓ POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

8.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

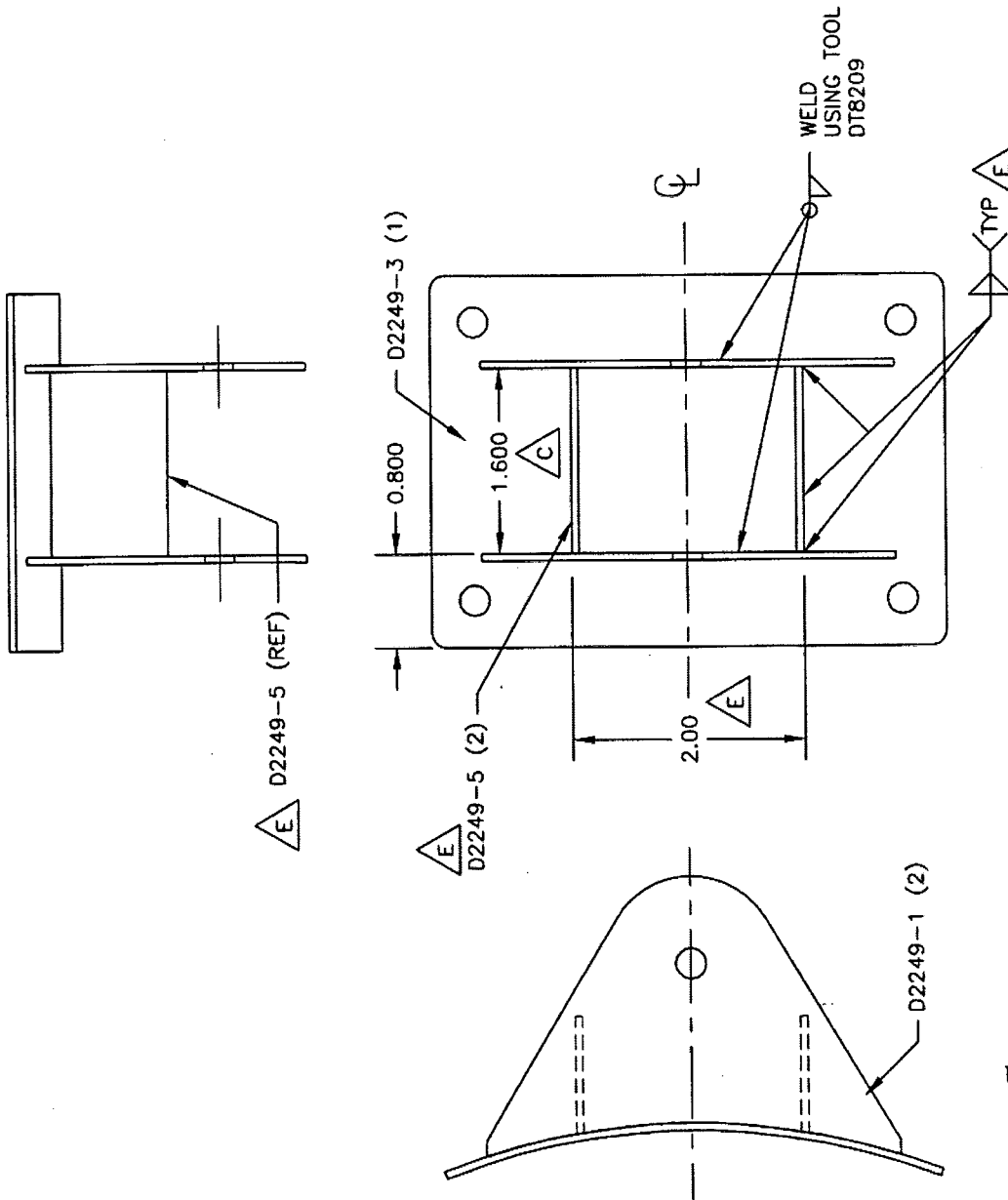
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
99.10.12 KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 	DRAWING NO. D2249	REV. E SHEET 1 OF 4
DATE 99.09.20		TITLE FITTING	SCALE NTS
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



D2249-041 ASSEMBLY

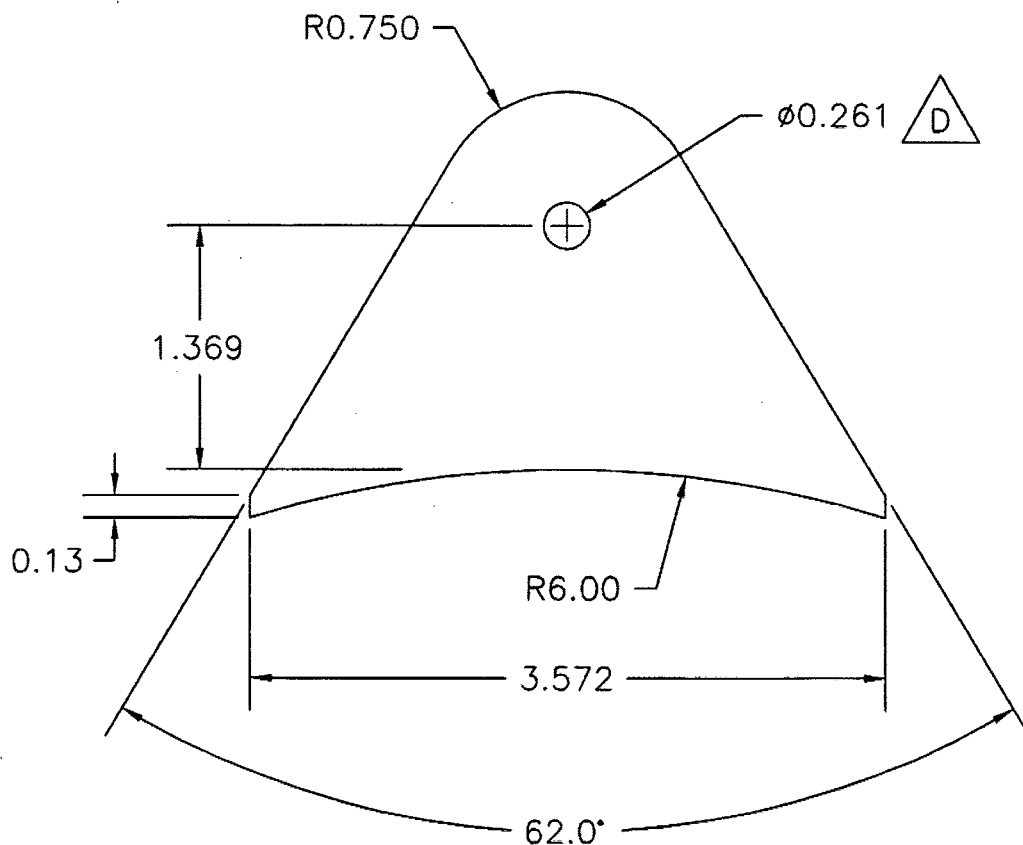
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 40893

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



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DATE 99.09.20	TITLE FITTING	SCALE 1:1	

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99.10.12 *KE*



D2249-1 LUG

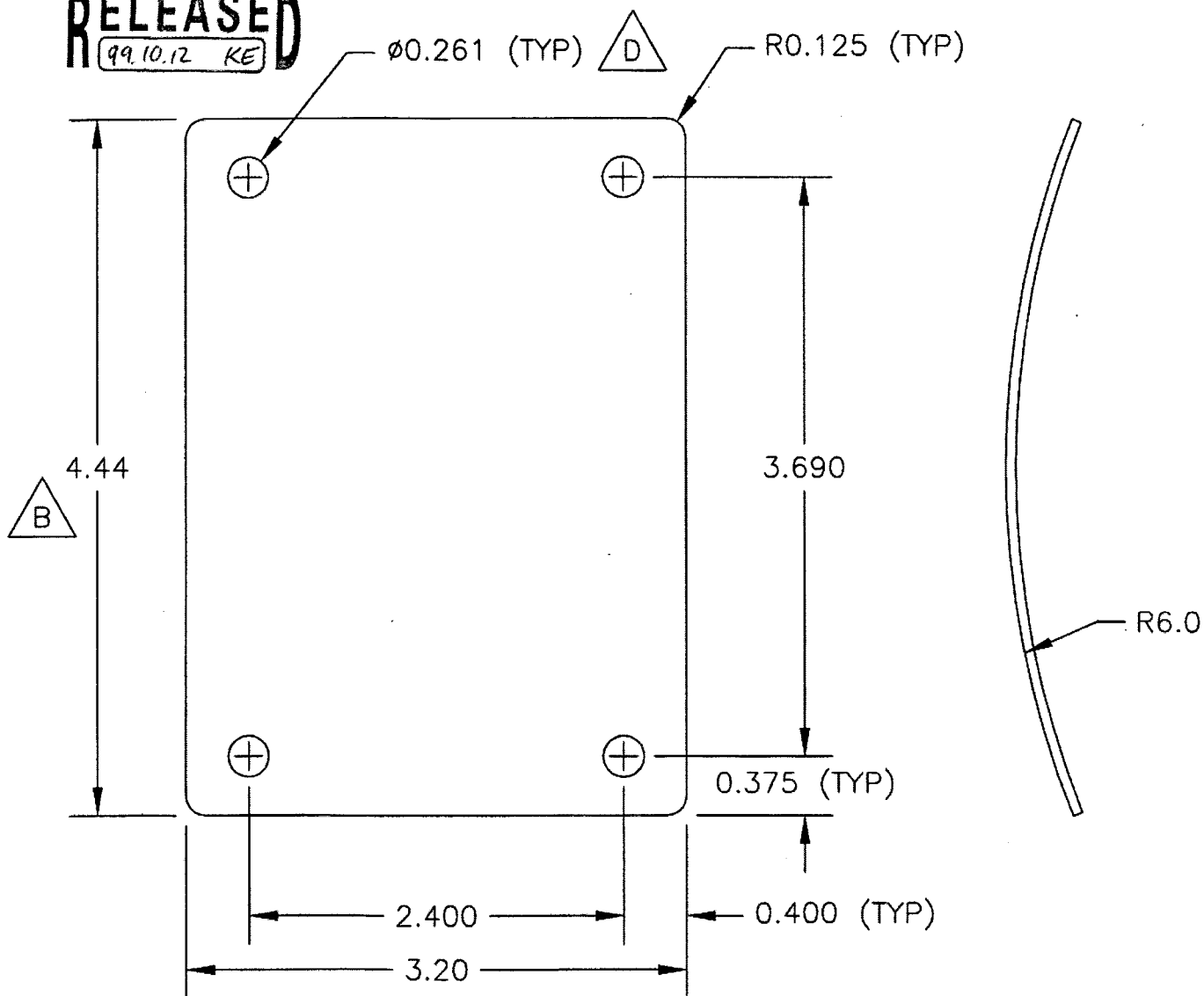
MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 40893



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DATE 99.09.20	TITLE FITTING		SCALE 1:1

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FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

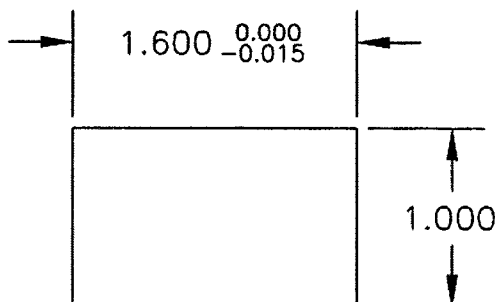
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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

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1999.10.12 KE



D2249-5 GUSSET

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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED